

Work Order ID 62936

Wednesday, October 13, 2010 2:55:07 PM



Page 1

Item ID:	D3836-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly (Basket Lid, LH)					
Start Date:	10/13/2010	Start Qty:	2.00	Cust Item ID:		
Required Date:	10/21/2010	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3836	Rev A

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- cut D3836-1 and D3836-3 rib as per dwg D3836								
	2- remove identification markings								
	3- deburr								
	4- weld D3836-1 to D3836-3 and drill hole (3/16") using D19447 jig and open to finish size as per dwg D3836								
	5- weld D2327-3 spacer bushing as per dwg D3836								
	A/R ER316 S.S. Rod Batch: 111585								
	6- grind weld flush where indicated on dwg								
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

2 *lpl* 10.10.19

SAN 10-10-15

PL 10.10.19

PD 10.10.19

2 *q*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				2			10-10-19
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00							SAD 10-10-19 (2)
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/10/2010 ME 10-10-19

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Picklist Print

Wednesday, October 13, 2010 2:55:11 PM

Page 1

Work Order ID: 62936

Parent Item: D3836-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 10/13/2010

Required Date: 10/21/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3 Manufactured No



Spacer Bushing

Location

Loc Qty

Loc Code

WA	33	
58974	1	
60320	1	
60952	11	
62108	20	

M304TS0.750W.065 Purchased No



304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT	662.0818	
112398	0	
114482	0.0002	
115494	82.0816	
115593	580	
WA	16.554385	
114520	0.527385	
115274	16.027	



1

2

Pl 10.10.19



1.7808

3.749053

SAD 10-10-15

3.7491

Dart Aerospace Ltd

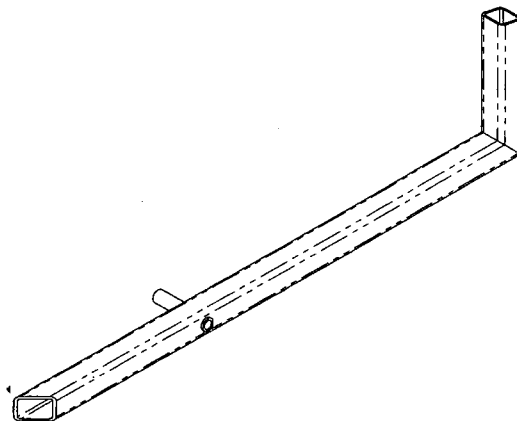
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

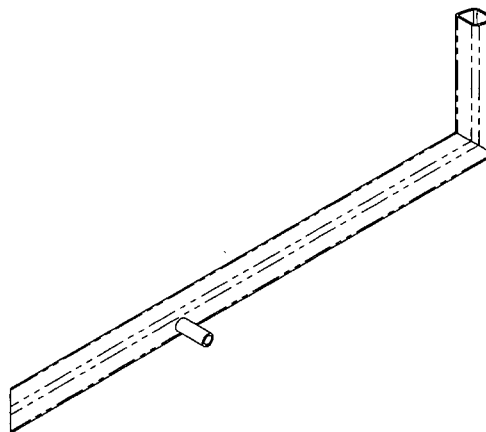
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NOTE: Date & initial all entries



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

STANDARD
REVISION
E-1000
UNCONTROLLED COPY
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER
NO. 62935
BS1010-13

RELEASED
08/11/13

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.99 lbs EACH
 8) WELD PER DART QSI 004

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3836	REV. A
TITLE RIB ASSY (BASKET LID)	SCALE NTS
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

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D

D

D3836-1
RIB

0.94

D2327-3
SPACER BUSHING

C

C

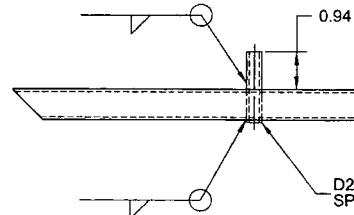
D3836-3
RIB6.00
REF

G

D3836-041 RIB ASSY (BASKET LID, LH)

B

B

D3836-2
RIBD2327-3
SPACER BUSHING6.00
REF

G

D3836-042 RIB ASSY (BASKET LID, RH)

B

A

A

w/o 62934

RELEASED
28/11/18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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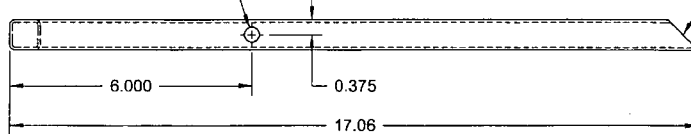
NOTE: Date & initial all entries

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CHAMFER

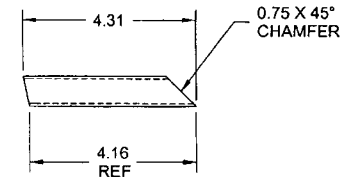


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER

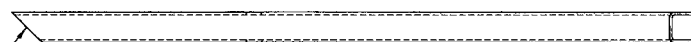


D3836-1 RIB



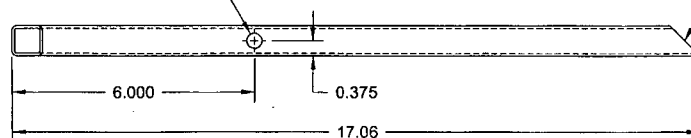
D3836-3 RIB

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CHAMFER

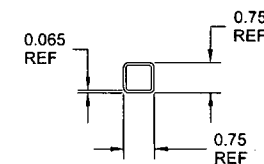


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
02/11/14

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1-2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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